

Work Order ID 59730

Thursday, June 10, 2010 9:57:07 AM



Page 1

Item ID: D3826-041

Accept



Setup Start



Revision ID:

Item Name: Rib / Gusset Assembly

Stop



Start Date: 6/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: M

Date: 10-6-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3826

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together
2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod
Batch: 1113328

M 10/06/17 5X
6x

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.06.21

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.06.21

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID:	D3826-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib / Gusset Assembly				Stop	
Start Date:	6/10/2010	Start Qty:	6.00			
Required Date:	6/17/2010	Req'd Qty:	6.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		<u>SAD</u> <u>16-06-21</u>		<u>6</u>			
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/06/22</u> <u>mf</u> <u>10-6-21</u>

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, June 10, 2010 9:57:11 AM

Page 1

Work Order ID: 59730

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Date: 6/10/2010

Required Date: 6/17/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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✓ D2235-1  Basket Rib		Manufactured	No				Each	8.0000	1	6		10/06/17	
--	--	--------------	----	--	--	--	------	--------	---	---	--	----------	--

Location Loc Qty Loc Code

WA 8
59035 8

✓ D3929-041  Gusset Assembly		Manufactured	No				Each	11.0000	1	6		10/06/17	
---	--	--------------	----	--	--	--	------	---------	---	---	--	----------	--

Location Loc Qty Loc Code

WA 11
57955 2
59070 9

✓ D3929-042  Gusset Assembly		Manufactured	No				Each	5.0000	1	6		10/06/17	
---	--	--------------	----	--	--	--	------	--------	---	---	--	----------	--

Location Loc Qty Loc Code

WA 5
59024 5

BS99 28

⑤
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

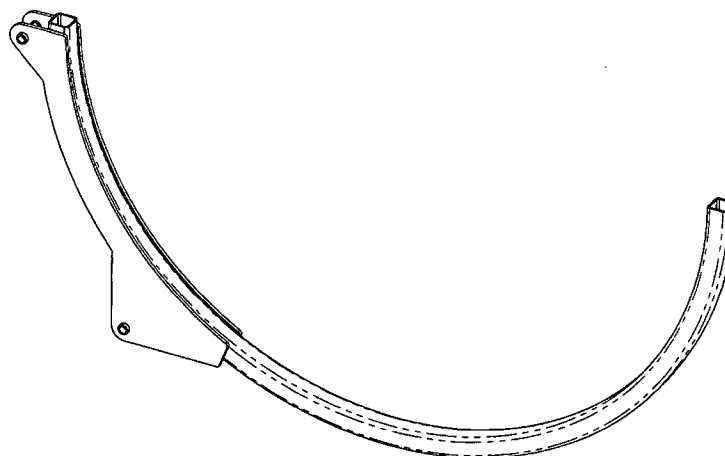
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59730
PS 10-610

RELEASED
8/10/12

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.32 lbs

B	D3929-041/042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.	RIB/GUSSET ASSY	NTS	
DATE	09.04.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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8 7 6 5 4 3 2 1

 D3929-042
GUSSET ASSEMBLY

 D3929-041
GUSSET ASSEMBLY

TYP







0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

W/O 59730

RELEASED
9/10/12

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
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8 7 6 5 4 3 2 1

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